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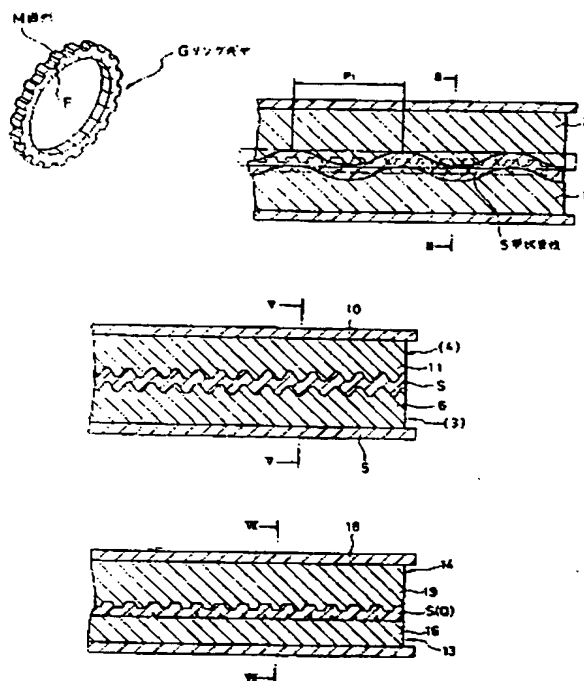
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TITLE : MANUFACTURE OF RING GEAR



ABSTRACT : PURPOSE: To accurately make up a prescribed ring gear without an excess or insufficient thickness by corrugating a band material with a larger pitch than that of the gear tooth profile, forming an intermediate bar-like product pressed into a tooth profile with prescribed pitch to a ring and butt welding the ends.

CONSTITUTION: The band material with specified length is pressed into a corrugated material S with the larger pitch than the tooth profile one. Said corrugated material S is preformed into the corrugation with prescribed pitch by an upper die 11 and lower die 6, then made into an intermediate bar-like product S(Q) by an upper die 19 of the tooth profile and a flat lower die 16. By making this corrugated material S, the flowing of the material thickness is uniformized and stabilized to prevent the defective forming such as an excess thickness or insufficient thickness. This intermediate bar-like product S(Q) is bent to the ring, then welded its ends to manufacture the prescribed ring gear G.

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